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Date: Wednesday, 11/21/2007 12:47:38 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	35916		Part Number	D2572		
Estimate Number	10531		Drawing Number	D2572 REV E		
P.O. Number	<i>N/A</i>		Project Number	N/A		
This Issue	11/21/2007	S.O. No. <i>N/A</i>	Drawing Revision	E		
Prsht Rev.	NC		Material	<i>N/A</i>		
First Issue	<i>N/A</i>	Type MACHINED PARTS	Due Date	1/15/2008	Qty:	12 Um: Each
Previous Run	34813					
Written By						
Checked & Approved By						
Comment	Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D6101005	7075-T7351 8.25X5.0X2.5		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: <i>B31388</i>		<i>On 07/12/22 (12)</i>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <i>35916</i> Double check by: <i>DSP</i>		
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.		<i>On 8F 08/01/03 (12)</i>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE		
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572		<i>On 8F 08/01/03 (12)</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE		<i>On 8F 08/01/03 (12)</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/01/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 35916

Part Number: D2572

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 08/01/04

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



12X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m-f

08/01/07

7.0 POWDER COATING POWDER COATING



M102316



12X

Comment: POWDER COATING

Powder Coat \*\*SANDTEX GREEN\*\*  
(Ref: 4.3.5.1) as per QSI 005 4.3

m-f

08/01/09

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



AS



X12

Comment: INSPECT POWDER COAT

08 - 01 - 09

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

AS 08/01/09

X12

10.0 QC21 FINAL INSPECTION/W/O RELEASE



12

Comment: FINAL INSPECTION/W/O RELEASE

08/01/11

Job Completion



u

08.01.11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35916
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.440	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.001	8.000	8.000		
F	0.490	0.510		0.498	.495	.500	.500		
G	0.257	0.262	DT8683	0.260	.258	.258	.258		
H	0.375	0.380	DT8684	0.376	.377	.377	.377		
I	0.490	0.510		0.500	.500	.500	.500		
J	1.174	1.184		1.178	1.180	1.180	1.180		
K	0.558	0.578		0.567	.567	.577	.570		
L	1.174	1.184		1.178	1.180	1.180	1.180		
M	1.490	1.500		1.493	1.500	1.500	1.500		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.872	3.872	3.872	3.872		
P	0.115	0.135		0.126	.126	.128	.128		
Q	0.115	0.135		0.135	.130	.132	.132		
R	0.240	0.260		0.249	.250	.252	.252		
S	0.115	0.135		0.134	.134	.131	.131		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.233	.230	.245	.242		
W	0.115	0.135		0.122	.125	.125	.125		
X	0.307	0.312		0.311	.311	.311	.311		
Y	0.760	0.765		0.760	.760	.760	.760		
Z	0.352	0.372		0.358	.358	.358	.358		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	.629	.629	.629		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.241	.241	.250	.250		
AE	1.375	1.395		1.387	1.390	1.390	1.390		
AF	0.115	0.135		0.135	.135	.135	.135		
AG	0.240	0.280		0.260	.210	.260	.260		
AH	0.240	0.260		0.247	.248	.250	.259		
AI	2.000	2.020		2.001	2.001	2.000	2.000		
AJ	0.023	0.043		0.033	.033	.033	.033		
Accept/Reject									

Measured by: *ml* / 8F  
 Date: 08/01/02 / 08/01/03

Audited by: *SD*  
 Date: 08/01/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>	

DART AEROSPACE LTD	Work Order:	35916
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5#	6#	7#	8#	By	Date
A	0.438	0.443	DT8682	.441	0.440	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	0.500	.502	.502		
G	0.257	0.262	DT8683	.260	.260	.260	.260		
H	0.375	0.380	DT8684	.376	.377	.377	.377		
I	0.490	0.510		.500	.500	.500	0.499		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.568	.568	.568	0.570		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.500	1.500	1.500	1.500		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.126	.126	.126		
Q	0.115	0.135		.125	.125	.125	0.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.125	.125	.125	0.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.963	2.963	2.963	2.963		
V	0.230	0.250		.240	.240	.240	0.238		
W	0.115	0.135		.125	.125	.125	.131		
X	0.307	0.312		.311	0.309	.310	.310		
Y	0.760	0.765		.765	0.760	.760	.760		
Z	0.352	0.372		.360	0.364	0.367	0.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	0.627	0.627	0.627		
AC	0.053	0.073		.063	.063	.063	0.063		
AD	0.240	0.260		.250	.250	.250	0.245		
AE	1.375	1.395		1.385	1.385	1.385	1.388		
AF	0.115	0.135		.125	.125	.125	0.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.250	.250	0.244		
AI	2.000	2.020		2.000	2.000	2.000	2.002		
AJ	0.023	0.043		.033	-0.033	.033	.033		
Accept/Reject									

Measured by: 815 / CMF  
Date: 07/12/29 / 08/01/02

Audited by: SA  
Date: 08/01/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<u>SA</u> <u>GD</u>

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Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	93	210	311	A12	By	Date
A	0.438	0.443	DT8682	.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.505	.505	.505	.502		
G	0.257	0.262	DT8683	.260	.260	.260	.260		
H	0.375	0.380	DT8684	.377	0.377	.377	.377		
I	0.490	0.510		0.500	0.500	.500	.500		
J	1.174	1.184		1.180	1.179	1.179	1.180		
K	0.558	0.578		0.570	.570	.570	.570		
L	1.174	1.184		1.180	1.179	1.179	1.180		
M	1.490	1.500		1.500	1.495	1.495	1.500		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.873	3.873	3.873		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		0.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.247		
S	0.115	0.135		0.131	1.129	.129	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.963	2.961	2.963	2.963		
V	0.230	0.250		0.235	.237	.240	.240		
W	0.115	0.135		.135	.135	.135	.135		
X	0.307	0.312		.311	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.360	.360	.360	.360		
AA	0.470	0.530		.500	.500	.500	.506		
AB	0.615	0.635		.630	.630	.630	.630		
AC	0.053	0.073		.063	.063	0.063	.063		
AD	0.240	0.260		.246	.246	.250	.250		
AE	1.375	1.395		1.388	1.386	1.386	1.386		
AF	0.115	0.135		0.135	.135	.135	.135		
AG	0.240	0.280		.260	.255	.260	.260		
AH	0.240	0.260		0.245	.246	.246	.250		
AI	2.000	2.020		2.002	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	85	/	2nd	Audited by:	SA
Date:	07/12/31	/	08/10/02	Date:	08/10/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SA



